Quality Control

December-19-12		015		*946	315*						Page 1
Revision ID:	3245-11 asket 9.01			Accept	*N9000	040	100)* s	Setup Star	1 7	S1* S2*
	2/19/12	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item IE Customer:	D :				IN	
Approvals:		n: <i> </i>	-		Dan Dan	te:		F	Run Star Stop		R1* R2*
Sequence ID/ Work Center ID		Operation Description	Calaborate	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
D3245	D										
*100 *100* Waterjet FLOW CNC Waterjet G89 Cloth		FLOW WATER JET Memo 1-Cut as pe Dwg Rev:_ Prog Rev:_	0	0.00				. 8	0		Jm 12/ 1-7-1
*110 *110* QC		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				G	٥		<u>Jm 1</u> -7-13

NCR:	Yes	1	No

											DQA:	Dat	te:		
NCR:	Yes	/ No				WORK ORDER NON-C	CON	FORN	MANCE / UPI	DATE					
											QA Closed:	Dat	e:		
Work Ord	er:					DISPOSITION		AGAINST			T DEPARTMENT/PROCESS				
Part NCR	-					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstul Machining Small F. Thermoforming Finishi Large Fab Composi			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root					1	ption of work order update	1	itial		ion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	n QC Inspector		
Doc/Data	Ы														
Equip/Tooling	Н														
Operator	Ш														
Material	Ц														
Setup	Ц		:												
Other	Щ														
Process	Н														
Supplier	Щ]			
Training	Н						ļ								
Unapproved															
							AULT	CATE	GORY						
Landi					_	General				_	7	r			
	\vdash	Bending	_			Bend	\vdash	irain			Ovalized	1	Pressure/Forced		
	\vdash	Centre No	ot Concer	itric to	^{O/S}	BOM/Route	\vdash	ardwa		<u> </u>	Over/Under	- -	Temperature/Cure		
	\vdash	Cracks				Broken/Damaged	\vdash	-	on Incomplete		Part Incorre		Weld		
	-	Crushed/0	Crimped.			Burrs	-		ions Incomplete/l	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled		
	$\boldsymbol{\vdash}$	Cuffs			ļ	Contamination	\vdash		nance		Part Moved				
	\vdash	Heat Trea				Countersink	\vdash	1islabe			Positioned V				
	\boldsymbol{H}	nspection		Tube		Cut Too Short	\vdash	1isread			Power Loss/	Surge	Other		
:	$\boldsymbol{\vdash}$	Ripples in				Drill Holes	\vdash	ffset							
	\vdash	Torque W		xtrusio	n _	Drawing	\vdash		Calibration						
	1	Turning So	equence			Finish	0	ot of S	equence						

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 94615 Page 2 December-19-12 1:08:33 PM Item ID: D3245-11 Accept Setup Start *N900040100* **Revision ID:** Gasket 9.01 Item Name: Start Oty: 4.00 12/19/12 **Start Date: Cust Item ID: Req'd Qty:** 4.00 Required Date: 1/11/13 **Customer:** Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Operation Set Up/ Accept Insp. **Work Center ID** Description Number Stamp **Run Hours** Code Qty Otv 120 OC8- Inspect parts - second check 0.00 *120* 0.00 B. 1-7 QC Memo Quality Control Identify as per dwg & Stock Location: \$7.33 130 *130* 0.00 Packaging Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140*

0.00

Memo

QC

Quality Control

13/1/10 /D) MUS 13-01-08

			DO	QA:	Date:
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date:		
Work Ord	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
	Part No				Scrap Machining Small Fab Use-as-is Thermoforming Finishing				Crosstube Small Fab Finishing Composite	Pro Rec/Stor	Engineering Quality Other		
Root				Descri	ption of work order update	I	nitial	Ac	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling													
Operator						1							
Material		1											
Setup													
Other													
Process													
Supplier													
Training													
Unapproved										<u> </u>			
						AUL	T CATE	GORY					
Landi	ng Gear				General					٦		7	
,	Bendin				Bend	\vdash	Grain		ļ	Ovalized	<u> </u>	Pressure/Forced	
	\vdash	Not Conce	ntric to	o/s _	BOM/Route	\vdash	Hardwa			Over/Under		Temperature/Cure	
	Cracks	_			Broken/Damaged	_	-	ion Incomplete		Part Incorre	—	Weld	
	_	d/Crimped	-		Burrs	_		ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs			<u> </u>	Contamination		Mainte			Part Moved			
	Heat Tr				Countersink	\vdash	Mislabe		<u> </u>	Positioned V		٦	
	_	ion Strip in	Tube		Cut Too Short	-	Misread	d		Power Loss/	Surge	Other	
		in Bend			Drill Holes	\vdash	Offset						
		Waves in I		n	Drawing	\vdash		Calibration					
!	_	Sequence			Finish	Ш	Out of S	Sequence				,	
	Wave/	wist in Tul	be		Folio		Outside	Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

December-19-12 1:08:33 PM

Work Order ID:

94615

Parent Item:

D3245-11

Parent Item Name:

Gasket 9.01

Start Date: 12/19/12

Required Date: 1/11/13

Start Oty: 4.00

Required Qty: 4.00

Comments:

IPP B04.12.06Made in-houseKJ/JLM

IPP Rev:C ecn 1052/water jet 07-11-05 DD verified :EC IPP Rev:C 12.11.07 PER DWG

REV.D DD VERF:JLM

	REV.D DD VER	1 .312141											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89 coated cloth		Purchased	No			100	sf	26.0000	0.0438	_0.1 844 2T	Σ		Jm 1-7-13
				I		I 04	•						

Page 1

		DQA:	Date:
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		

										QA Closed:	Date	:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap Use-as-is	- - - - -	ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR 1	No				Work Order Update]		Large Fab	Composite]	Supplier	
Root	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			Descri	ption of work order update	In	itial	Ac	tion	Sign &		
Cause	Date	Step	Qty	•	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling											i	
Operator												
Material						1					:	
Setup												
Other												
Process												
Supplier												
Training												
Unapproved			<u> </u>									<u> </u>
	***				<u> </u>	AULT	CATE	GORY				
Landi	ng Gear				General							_
	Bending			L	Bend	Щ	Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped	-	L.	Burrs		nstruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		_
	Heat Tre	at			Countersink		Mislabe	eled	[.	Positioned V	Vrong	
	Inspection	on Strip in	Tube		Cut Too Short		Misreac	t		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset					
	Torque \	Waves in 8	Extrusion	· [Drawing		Out of 0	Calibration				
	Turning	Sequence			Finish		Out of S	Sequence				
	Wave/T	wist in Tul	oe		Folio	П	Outside	Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 944	15
Description: Gastet 9.01"	Part Number: 03245	-11
Inspection Dwg: 1/3245 Rev: 1)	Page	1 of 1

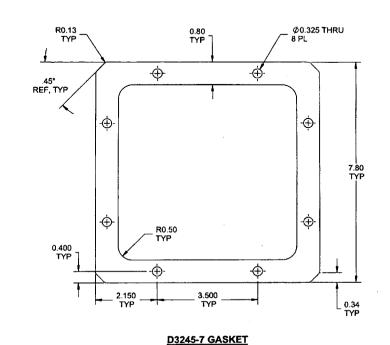
FIRST ARTICLE INSPECTION CHECKLIST

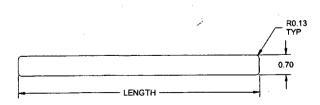
	TIKOT AKTIOLE INOI EOTION OTLONEIOT										
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
0,70"	11-0030"	6.70"			V	Produtos					
9,01"	4/-0030" 4/-0030"	9.01"			V						
,											
					- M						
				-		0.0010					
				_							

Measured by:	Tm	Audited by: Sm	Preliminary Approval:	
Date:	121-7-13	Date: 13 1.7	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

\$ 10.04.15





D3245-X GASKET

P/N	LENGTH
D3245-9	8.35
D3245-11	9.01
D3245-13	9.50

94615 7 Rl 13-01-2

	1			
DESIGN	7#	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	30	DRAWING NO.	REV. D	
MFG. APPR.	M o	D3245	SHEET 7 OF 7	
APPROVED	TAMP	TITLE	SCALE	
DE APPR.		ACCESS PANEL ASSY	NTS	
DATE 12.10.16		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT & PRIMATE AND CONTRIBUTION AND EXPRED ON THE SOFFEED COMPRISE TO ANY OTHER PRIMATE OF ANY OTHER PRIMATE		

NOTES:

1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D3245-7 = 0.04 lbs; D3245-9/-11/-13 = LESS THAN 0.01 lbs

D